

PRELIMINARY ISSUE

Work Order ID 64159



Thursday, November 25, 2010 4:01:39 PM

Page 1

Item ID: D4298-009

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Plate

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00



Customer:



Reference:

Approvals:

Process Plan:

Date: 10/11/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4298

PA1 Rev A

100



FLOW WATER JET

Waterjet

Memo

0.00

0.00

BS 10-12-1

BS 10-12-3 ①

FLOW CNC Waterjet

6061-080

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

BS 10-12-1

BS 10-12-3

Ph →

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

→ 8 10-12-3 (①)
Inspection Enr4 Day
-009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/02 # 110		Qty +1 Part (the only one) scrap . hole was drilled in the incorrect location R.C. operator Read Day incorrectly 10/12/02		- Script Destry Redrill m# <u>116268</u>	10/12/02 3	10/12/02 S	10/12/02 S	10/12/02 S
		Lock of Attention and Program were wrong.	10/12/02	- Fit program	10/12/02		10/12/02 S	10/12/02 S

NOTE: Date & initial all entries

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Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling: _____ Date: _____

Run Start



QC:

Date:

SPC (Y/N): _____ Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130



Small Fab

Small Fab

Memo

1- C'sink holes as per rivet size and dwg, deburr

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

- inspect to end by
- 00-1

Memo

0.00

8/12/08 (T)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

=> 10/12/09

0.00

1 - 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4298-009

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Setup

Start



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Item Name: Plate

Start Date: 11/25/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

155



Powdercoat

Powder Coating

**Operation
Description**

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

16288

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

11 10/12/09



170



Packaging

Packaging

Identify as per dwg & Stock Location: GA

B64184

0.00

SD 10/12/10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Plate

Start Date: 11/25/2010 Start Qty: 1.00

Required Date: 12/3/2010 Req'd Qty: 1.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10.11.29 AUTH AA
RELEASED JDATE 10.12.17 X1

ASSEMBLED

*PS 10/12/10
D*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, November 25, 2010 4:01:43 PM

Work Order ID: 64159



Parent Item: D4298-009



Parent Item Name: Plat

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.24 new issue DD Verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	7.4150	0.03875	0.040789			

6061-T6 .080 Sheet



1810-12-1

Location	Loc Qty	Loc Code
MAT	7.415	
115689	7.415	
116268		115689
		116268 1810-12-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64159
Description: PLATE	Part Number:	D4298-669
Inspection Dwg: D4298-669 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

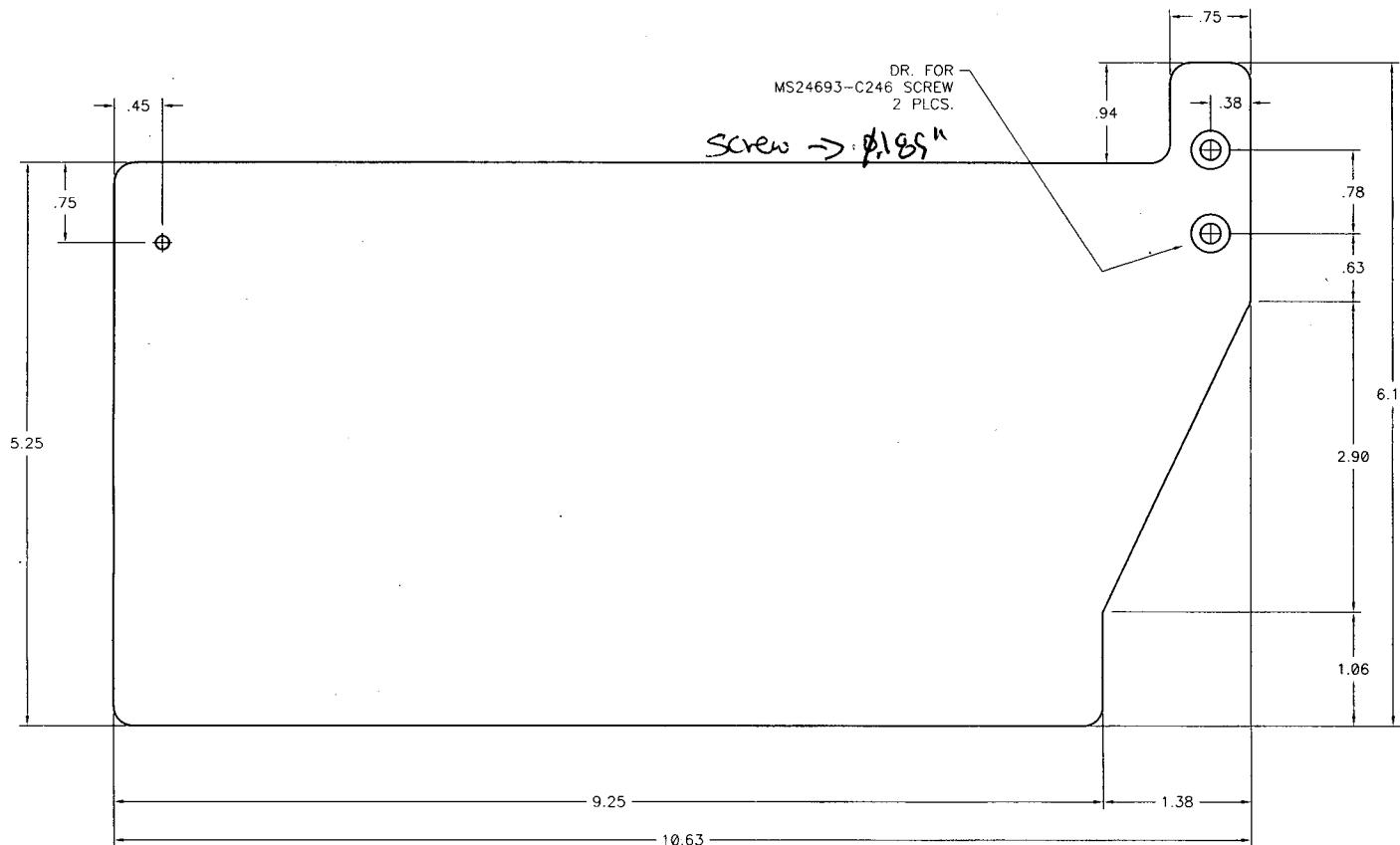
X First Article X Prototype

Measured by:	13
Date:	10-18-13

Audited by: SD
Date: 10/12/03

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64159

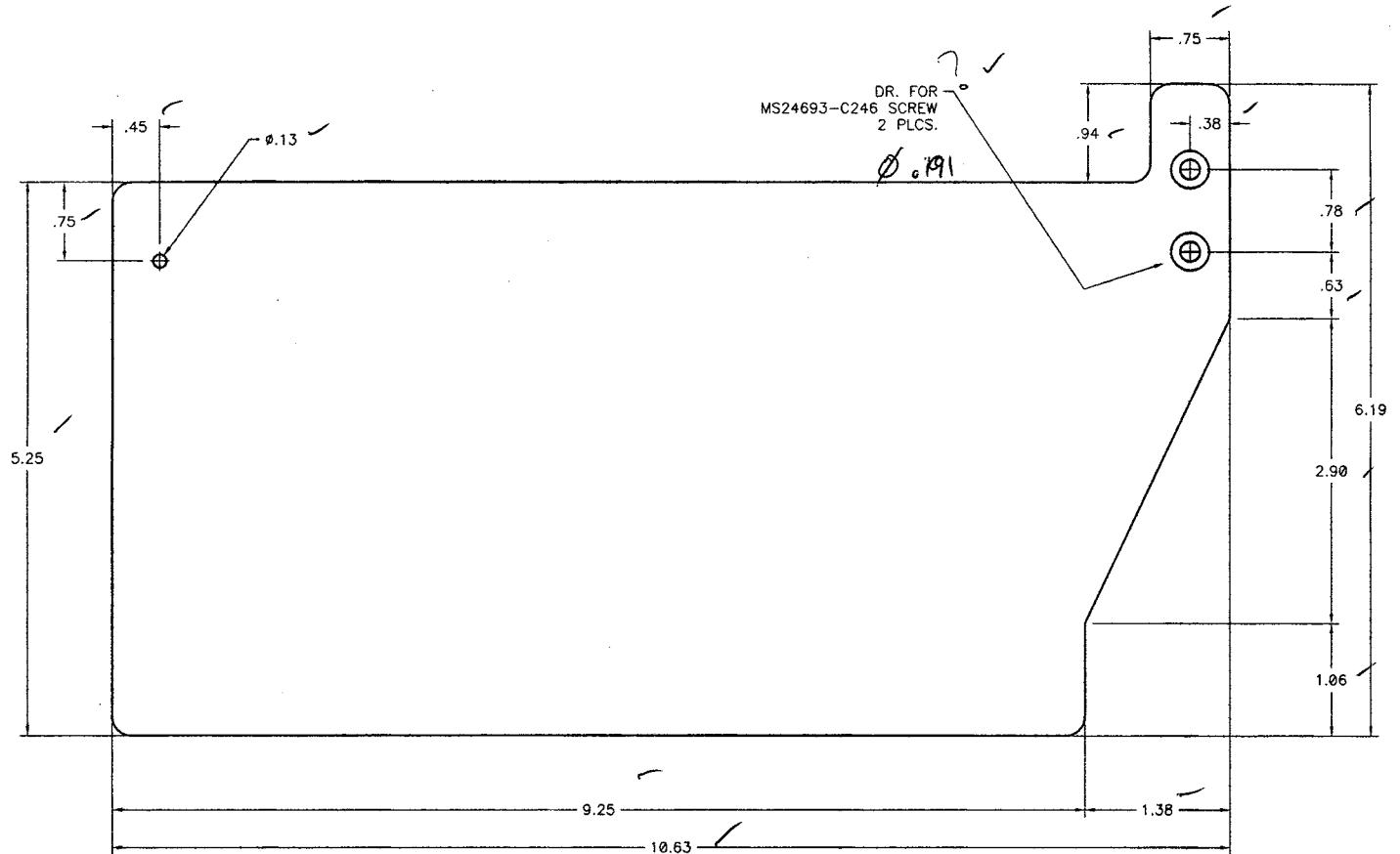
BB 10-11-26

-009 PLATE

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Era Helicopters LLC

TITLE	SINGLE PILOT VFR CHART HOLDER, AW139	SIZE	DWG. NO.	REV.
		C	13939-1-290 SHT 5 OF 10	A



W.B. 64159

-009 PLATE

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TITLE	SINGLE PILOT VFR CHART HOLDER, AW139	SIZE ○	DWG. NO. 13939-1-290 SHT 5 OF 10	REV. D

DART P/N	ERA P/N	Description
D4298-001	13939-1-290-001	CHART HOLDER ASSY
D4298-002	13939-1-290-002	PLATE SUB-ASSY
D4298-003	13939-1-290-003	PLATE SUB-ASSY
D4298-004	13939-1-290-004	FIXING BRACKET SUB-ASSY
D4298-005	13939-1-290-005	HINGE SUB-ASSY
D4298-006	13939-1-290-006	MACHINED INNER SUB-ASSY
D4298-007	13939-1-290-007	MACHINED OUTER SUB-ASSY
D4298-008	13939-1-290-008	PLATE
D4298-009	13939-1-290-009	PLATE
D4298-010	13939-1-290-010	FIXING BRACKET
D4298-011	13939-1-290-011	HINGE
D4298-012	13939-1-290-012	HINGE
D4298-013	13939-1-290-013	HINGE
D4298-014	13939-1-290-014	HINGE
D4298-015	13939-1-290-015	CLIP ANGLE
D4298-016	13939-1-290-016	CLIP STOP
D4298-017	13939-1-290-017	CLIP STOP MOUNT
D4298-018	13939-1-290-018	MACHINED INNER
D4298-019	13939-1-290-019	MACHINED OUTER
D4298-020	13939-1-290-020	KNOB
D4298-021	13939-1-290-021	MACHINE BOLT
D4298-022	13939-1-290-022	PIN TOPPER
D4298-023	13939-1-290-023	PIN
D4298-024	13939-1-290-024	SERRATED ADJUSTMENT WASHER

WFO 645

RELEASED
2010-12-15

[Signature]

A	NEW ISSUE		SC	10.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	SC			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>[Signature]</i>	D4298	SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	CHART HOLDER (AW 139)	NTS	
DATE	10.12.15			
<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>				

Eric Charbonneau

From: Domingue, Elvin [edomingue@erahelicopters.com]
Sent: November 24, 2010 1:48 PM
To: Nelson, David; 'echarbonneau@dartaero.com'
Subject: Re: DXF files (AW139 Chart Holder)

Yes that would be perfect!

Elvin Domingue
Sent from my BlackBerry Wireless Device

From: Nelson, David
To: 'Eric Charbonneau' <echarbonneau@dartaero.com>
Cc: Domingue, Elvin
Sent: Wed Nov 24 12:37:04 2010
Subject: RE: DXF files (AW139 Chart Holder)
Eric,

That sounds okay to me, but I'll fwd to Elvin Domingue on this.

Elvin, does this finish sound okay for the AW139 Chart Holder?

Thanks,
David

From: Eric Charbonneau [<mailto:echarbonneau@dartaero.com>]
Sent: Wednesday, November 24, 2010 12:10 PM
To: Nelson, David
Subject: RE: DXF files

Thanks David, at the same time would you know what kind of finish is required on the assembly, most of our interior parts we alodine and then powder coat black sandtex, this black is satin and prevent any glare. If this is what you would like please let me know, or fwd this to whoever can help me out with this.

Thank,
Eric

From: Nelson, David [<mailto:dnelson@erahelicopters.com>]
Sent: November 24, 2010 11:53 AM
To: 'Eric Charbonneau'
Subject: RE: DXF files

Here you go.

Thanks,
David

From: Eric Charbonneau [<mailto:echarbonneau@dartaero.com>]
Sent: Wednesday, November 24, 2010 10:11 AM